

Date: Tuesday, 10/3/2006 3:41:42 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID  
 Job Number : 28847  
 Estimate Number : 10549  
 P.O. Number : N/A Part Number : D206642311  
 This Issue : 10/3/2006 S.O. No. : N/A Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A  
 Previous Run : 28846 Material : N/A  
 Due Date : 10/30/2006 Qty: 1 Um: Each  
 Written By : [Signature]  
 Checked & Approved By : [Signature]  
 Comment : Est Rev: 005.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-311 CHG004

KJ 061012 (1)

2.0 28847A 206 L HIGH GEAR SKIDTUBE



Comment: Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE

D206-642-341 B 28847A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D2652 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

BUSHING

Pick:

Qty	Part Number	Description	Batch
24	D2652	Bushing	1329996 - ✓
1	D206-642-341(REF)		28847A ✓

5.0 D2655 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

TOW RING

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:41:43 PM  
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## Process Sheet

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Drawing Name: 206L/L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 28847

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2655 Tow Ring

B27116 - ✓

6.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LUG ASSEMBLY

Pick:

Qty	Part Number	Description	Batch
2	D2659	Lug Assembly	B28857 ✓

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

SET SCREW

Pick:

Qty	Part Number	Description	Batch
10	D2712	Set Screw	B26481 - ✓

8.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2932-1	Saddle	B28668 ✓

9.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2933-1	Saddle	B28669 ✓

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty	Part Number	Description	Batch
2	D2934	Saddle Spacer	B28920 - ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28847

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty	Part Number	Description
2	D2935	Saddle Spacer

Batch

B28921 - ✓

12.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description
1	D2938-1	Saddle

Batch

B28862 - ✓

13.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description
1	D2939-1	Saddle

Batch

B27207 - ✓

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

TOW RING

Pick:

Qty	Part Number	Description
1	D2968-043	Tow Ring

Batch

B28860 - ✓

15.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
4	AN3-37A	Bolt

Batch

M14478 - ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28847

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
8	AN3-41A	Bolt	M102658 3X/ M102850 - X5

17.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
1	AN4-5A	Bolt	M100857 -

18.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
12	AN4-6A	Bolt	M102989 -

19.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
4	AN5-10A	Bolt	M102083 -

20.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
8	AN5-11A	Bolt	M103044 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28847

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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
4	AN5-12A	Bolt

Batch

M101943 - ✓

22.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
12	AN960JD10	Washer

Batch

M100743 - ✓

23.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
1	AN960JD1016	Washer

Batch

M5519 - ✓

24.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
25	AN960JD416	Washer

Batch

M101938 - ✓

25.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
8	AN960JD516	Washer

Batch

M100564 - ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28847

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
1	AN970-4	Washer

Batch

M102929 ✓

27.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

NUT

Pick:

Qty	Part Number	Description
12	MS21042L3	Nut

Batch

M102217 ✓

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

NUT

Pick:

Qty	Part Number	Description
13	MS21042L4	Nut

Batch

M19185 ✓

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-311

Location:

PPP Rev: D

Box 101/200 Per 101/200 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/01/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Tuesday, 10/3/2006 3:41:44 PM  
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## Process Sheet

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Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 28847

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107/01/09 (1)

Job Completion



U 07-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:42:42 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L HIGH GEAR SKIDTUBE
Job Number	: 28847A		
Estimate Number	: 10539		
P.O. Number	: N/A	Part Number	: D206642341
This Issue	: 10/3/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2650 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28846A	Drawing Revision	: E
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/30/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	1 Um: Each
Comment	: Est Rev: H-05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-341 CHG002

N/A

2.0

D2620

Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2620

Bent Tube 3" OD

B27932

Pm '06-11-7①

3.0

D2647

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2647

Fwd Cap

B26 B24842

BE 6-11-7

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

Pm '06-11-7①

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

Pm '06-11-7①

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R

Aluminum Rod

M101010 / M101655

BE 06-11-7

4-Grind weld flush to cap on top surface only.

Pm '06-11-15①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Tuesday, 10/3/2006 3:42:42 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28847A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end to length as per dwg D2650 *Pm 06-11-15 ①*

6-Drill pilot holes using drill Jig DT8168A (A, & B). Open to Ø0.312" *Pm 06-11-16 ①*

7-Drill holes for wearplates using DT 8028-5. Open to Ø0.297" *Pm 06-11-16 ①*

8-Open Aft Cap Hole using #6 Drill Bit *Pm 06-11-16 ①*

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail *Pm 06-11-16 ①*

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650 *Pm 06-11-16 ①*

11-Deburr and Blow out all chips from inside the tube *Pm 06-11-16 ①*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M.B 06/11/20 ①*

6.0

D26545

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-5

Web

*B21093*

*Pm 06-11-21 ①*  
*M.B 06/11/21 ①*

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) *Pm 06-11-21 ①*

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid) *Pm 06-11-21 ①*

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. *Pm 06-11-21 ①*

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: *06/11/21* Time: *11:10 AM*

Finish Date: *06-10-06* Time: *11:4 AM*

A/R Sikaflex-291

*M102660*

Sikaflex expiry date: *07-02-01*

*Pm 06-11-21 ①*  
*M.B 06/11/21 ①*

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	①						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			13210					

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28847A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*206-12-06 (1)*

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

17 D2649

Crossbolt spacer

*229329 BE 07-01-04*

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

*m 101010 BE 07-01-04 in*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

*pm 07-01-08 (1)*

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

*pm 07-01-09 (1)*

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

*B24203 pm 07-01-09 (1)*

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

*m18546 pm 07-01-09 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28847A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

M19099

Pm 07-01-09 (2)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Pm 07-01-09 (2)

15.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

07/01/09 (1)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

yl 07/01/22 x1

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pu 7/01/22 (1)

18.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B29038

19.0

D265611

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-11

Wearshoe

B16357

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28847A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B17527

21.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-35

Wearshoe

B26206

22.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B29201

23.0

ALS41032130

Insert



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 ALS4-1032-130

Inserts

M162425

or (see QSI 017)

24.0

AN960JD10L

Washer



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 AN960JD10L

Washer

B102217

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 10/3/2006 3:42:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28847A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS27039108

Screw



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 MS27039-1-08

Screw

B102404

26.0

D26511

Plug



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-1

Plugs

B24005

27.0

D26513

O-Ring



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-3

O-Rings

B28692

28.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

B11151

29.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

B36874

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:42:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28847A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B28041

31.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer

B102217

32.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw

B102404

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expiry date:

M102672  
02/07

FR/M

07/01/22

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

(1)

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

Sikaflex expiry date:

M102672  
02/07

FR/M

07/01/22(1)

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: M102635

FR/M

07/01/23

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 07/01/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:42:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 28847A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

QC3/5

INSPECT WORK/WING WALK



*M 07 01 25*



①

Comment: INSPECT WORK/WING WALK

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*PAP*

*B28847*

*07/01/25*

36.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

*07/01/25*

Job Completion



*U 07.01.29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**RELEASED  
16 04 17 #

DESIGN <i>AP</i>	DRAWN BY <i>AP</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

**NOTES**

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


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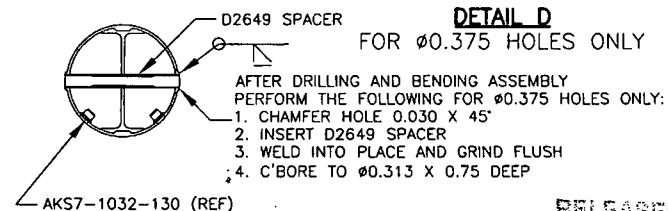
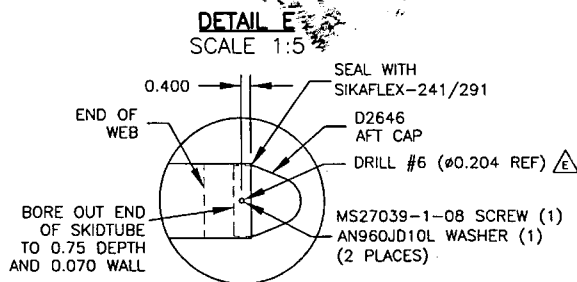
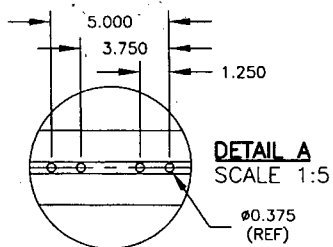
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<b>DART</b>		<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWING NO.		REV. E	
D2650		SHEET 2 OF 5	
TITLE		SCALE	
SKIDTUBE		1:10	

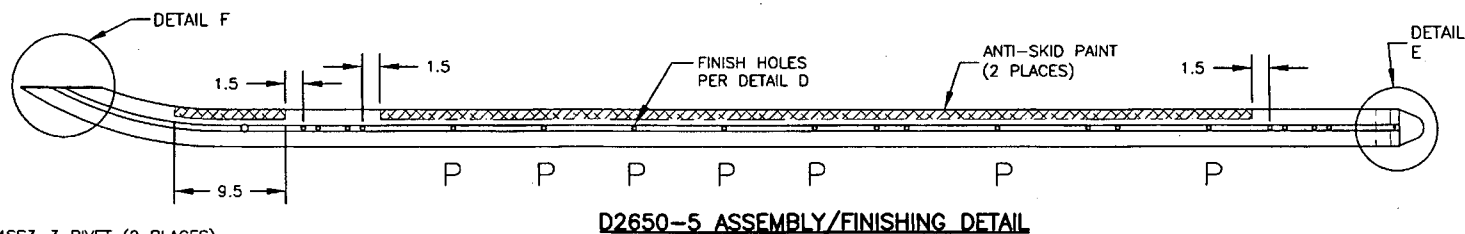
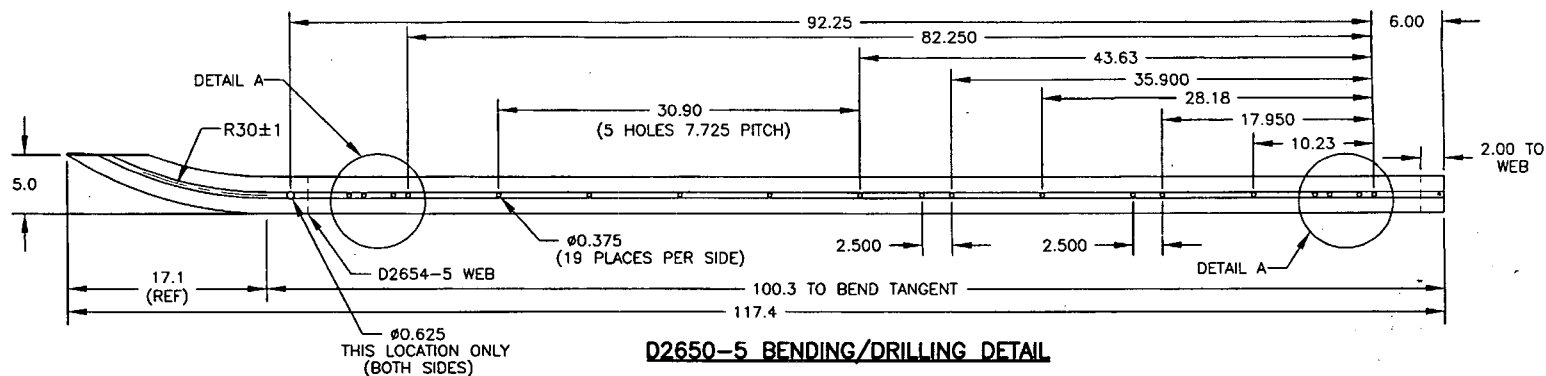


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	CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>		DRAWING NO. <b>D2650</b>
	DATE <b>06.03.30</b>	TITLE <b>SKIDTUBE</b>		REV. SHEET 3 OF 3





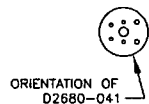
RELEASED



**DETAIL F (NOT TO SCALE)**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

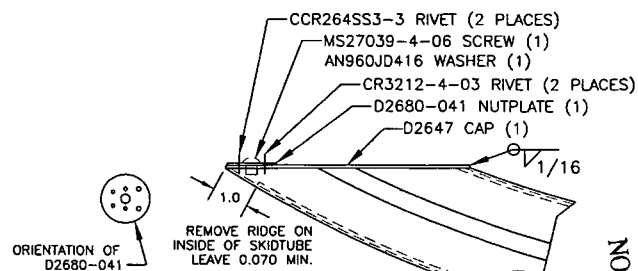
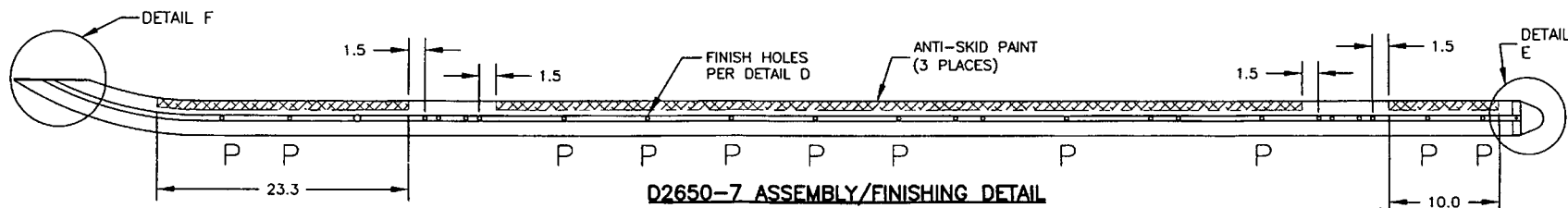
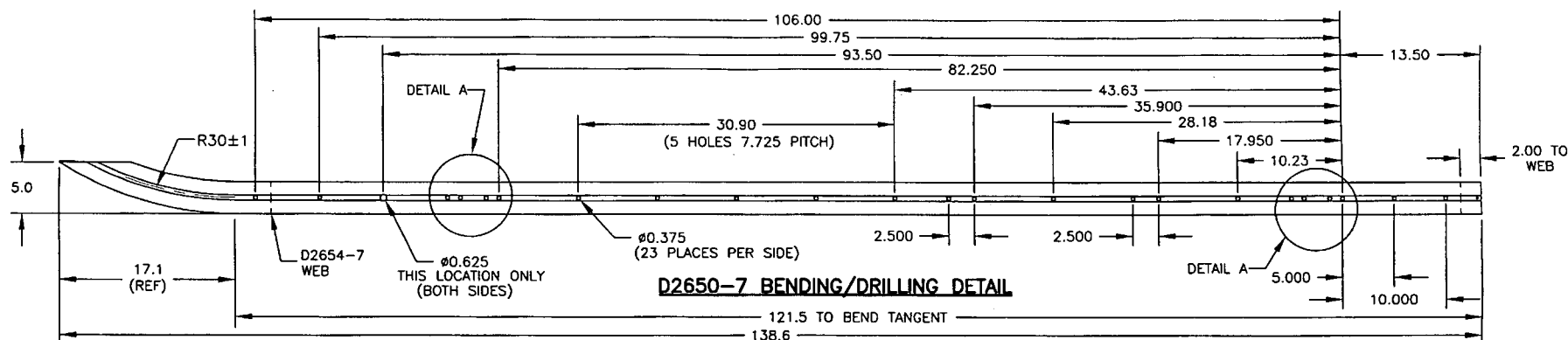
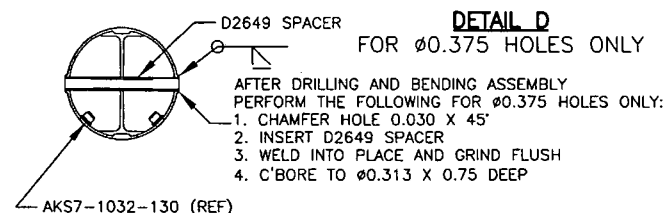
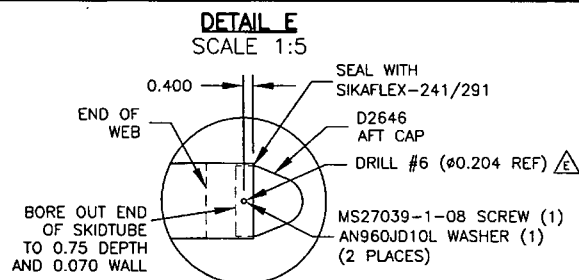
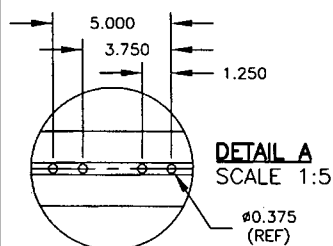
NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.

NO. 288774  
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CHECKED	PH	APPROVED	PH	DRAWING NO. D2650
DATE	06.03.30	TITLE	SKIDTUBE	REV. E SHEET 4 OF 5 SCALE 1:10



- DETAIL F (NOT TO SCALE)**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

NO. 28871A

WORK ORDER

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DESIGN	UP	DRAWN BY	UP	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. E
CHECKED	#4	APPROVED	#4	DRAWING NO. D2650	SHEET 5 OF 5
DATE	06.03.30	TITLE	SKIDTUBE	SCALE	1:10

RELEASED

av. 17

NO. 84

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number A206642341 / B28347A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down	Up
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

*Welding positions 1G, 2G, 3G, 4G, 5G, 6G, 1F, 2F, 3F, 4F, 5F are marked with a large 'N/A' across the table.*

Crossbolt Spacer Welded into

Skid

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐

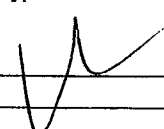
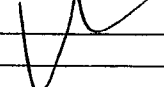
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/01/09 Qualifier David Auld

Date: Thursday, 11/10/2007 2:26:44 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-642
Job Number : 35132	
Estimate Number : 10804	
P.O. Number :	Part Number : Z_CUSTOM
This Issue : 11/10/2007 S.O. No. :	Drawing Number : ECN 1046-PAPERWORK
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LANDING GEAR	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 18/10/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 REMOVE FROM STOCK:

D206-642-111 15614 15615  
 D206-642-112 10319 25504  
 D206-642-141 9075 18613  
 D206-642-211 33078 32559 - 32565 - 33795 - 33776  
 D206-642-212 32257 32567 - 32566 - 32568 - 33079 - 33080 - 33242  
 D206-642-213 19735  
 D206-642-214 24414 - 24484 - 28083 - 29081 - 32983 - 32984  
 D206-642-241 28097 - 28604 - 33211 - 33342  
 D206-642-311 28847  
 D206-642-312 29741 - 15619 - 29742 - 29744  
 D206-642-341 34557 34056 - 34555 - 34556 - 32495 - 31980  
 D206-642-411 34132  
 D206-642-411BL 34569 - 34563 - 34562 - 34060 - 34059 - 32502 - 31058  
 D206-642-412 34735  
 D206-642-412BL 34735  
 D206-642-441 31066 - 30940 - 30260 - 30265 - 24739  
 D206-642-511 34582 - 34579 - 33848 - 34581  
 D206-642-512 34586 - 34584 - 34583  
 D206-642-513 \_\_\_\_\_  
 D206-642-514 \_\_\_\_\_  
 D206-642-541 \_\_\_\_\_  
 D206-642-611 \_\_\_\_\_  
 D206-642-612 \_\_\_\_\_

ADD NEW PAPERWORK EASA.IM.R.S.01320 REV.1  
 PER ECN 1046

1-11-09 SP